



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3078-041
Job Sheet 187019



Part No: **D3078-041**

Job Qty: **4 ea**

Part Name: Step Assembly, Hi Short LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/26/18

Job Tracking No:

Due Date: 11/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 15.11.12 NEW ISSUE DD VERF:JLM IPP REV:B 16.03.15 DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/29/18	0.00	0.00	Start Up Large Fab-4		MAZ
110	Large Fab	4 pcs		11/29/18	0.00	4.04	Large Fab 8		MAZ
120	QC	4 pcs		11/29/18	0.00	0.00	QC6		CPC
130	Large Fab	4 pcs		11/29/18	0.00	4.04	Large Fab 2		CPC
140	QC	4 pcs		11/29/18	0.00	0.00	QC9		SL
150	QC	4 pcs		11/29/18	0.00	0.00	QC5		SL
160	HandFinish	4 pcs		11/29/18	0.00	0.47	HandFinish1		D.R. 18/11/28
170	QC	4 pcs		11/29/18	0.00	0.00	QC7-2		38
200	Large Fab	4 pcs		11/29/18	0.00	4.04	Large Fab 2		SL 9-89
210	QC	4 pcs		11/29/18	0.00	0.00	QC10		CPC
220	QC	4 pcs		11/29/18	0.00	0.00	QC5		CPC
240	HandFinish	4 pcs		11/29/18	0.00	0.47	HandFinish6		D.R. 18/12/13
250	Powdercoat	4 pcs		11/29/18	0.00	0.91	Powdercoat1		BR 18-12-18
260	HandFinish	4 pcs		11/29/18	0.00	0.47	HandFinish3		DEB 18-12-19
270	QC	4 pcs		11/29/18	0.00	0.00	QC3		D 18-12-21
290	Packaging	4 pcs		11/29/18	0.00	0.00	Packaging3-1		200 DAS
300	QC21-SA	4 Ea		11/29/18	0.00	0.00	QC21		DEC 27 2018 70

Part Op 110 - 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680
Descriptions: for rivets. 3-Deburr

130 - 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3072 A/R
Aluminum Rod M130137 3-Grind End Plate flush

200 - 1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024

4-Weld Aft End Plate as per QSI-004 & Dwg D3078 A/R Aluminum Rod 200 5-Grind End Plate flush

250 - START TIME: 11:45 OVEN TEMPERATURE: 320 FINISH TIME: 12:15

M 138951

wingwalk M 138963.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 Ea (.5 ea)	90-Start up Operation	S 104007
D3067-1	End Plate	8 Ea (2 ea)	130-Large Fab	5125543
D3219-3	Plate	8 Ea (2 ea)	130-Large Fab	5107461-7
D3065-041	Step Leg Assembly	4 Ea (1 ea)	200-Large Fab	5081006-1
D3066-1	Spacer	8 Ea (2 ea)	200-Large Fab	5128757

S132646

6904

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	2	327	0
130-Large Fab	D3067-1	8	221	0
	D3219-3	8	17	0
200-Large Fab	D3065-041	4	1	0
	D3066-1	8	310	0
	MS20600-AD4W4	64	2,238	0

Part Specifications

Specifications could not be found.

Plex 11/26/18 10:27 AM Dart.lajeunesse.marie

**Container No: S131495****Part: D3078-041****Job No: 187019****Serial No/Batch: S131495****Revision:****Inspector:****Exp Date:****Instructions: Various STC's**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/26/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			